



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

1355

**RBEM622U3001101**  
**Job Sheet 181877**



**Part No:** RBEM622U3001101

**Job Qty:** 1 ea

**Part Name:** Conical Extractor



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 8/10/18

**Job Tracking No:**

**Due Date:** 10/15/18

**Created By:** Logan David

**Type:** SOLD

**Description:**

**Note:** DWG RBEM622U3001101 Rev. 2 IPP Rev. A 18.06.26 new issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 1 Ea  |            | 10/15/18 | 0.00      | 0.00    | Start Up Small Fab-4  |           | MLL      |
| 110   | Small Fab          | 1 pcs |            | 10/15/18 | 0.00      | 1.00    | Small Fab-4           |           | MLL      |
| 120   | QC                 | 1 pcs |            | 10/15/18 | 0.00      | 0.00    | QC5                   |           | SA       |
| 130   | Small Fab          | 1 pcs |            | 10/15/18 | 0.00      | 0.50    | Small Fab-4           |           | MLL DAS  |
| 140   | QC                 | 1 pcs |            | 10/15/18 | 0.00      | 0.00    | QC5                   |           | 38       |
| 150   | Packaging          | 1 pcs |            | 10/15/18 | 0.00      | 0.00    | Packaging3            |           | MLL 9-89 |
| 160   | QC21-FG            | 1 Ea  |            | 10/15/18 | 0.00      | 0.00    | QC21                  |           | DAS      |

Part Op 110 - Assemble as per DWG sheet 1.

Descriptions: 130 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1300-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

OCT 23 2018

### Job BOM

| Part / Item                   | Component Name                         | Quantity    | Operation             | Container |
|-------------------------------|----------------------------------------|-------------|-----------------------|-----------|
| 134A RBEM622U3001101-11       | Hex Head Cap Screw                     | 3 Ea (3 ea) | 90-Start up Operation | 5113675   |
| 63 90128A263                  | Socket Head Cap Screw, M6 X 1mm X 16mm | 2 Ea (2 ea) | 110-Small Fab         | 5093271   |
| 67 91166A270                  | Washer, M8                             | 3 Ea (3 ea) | 110-Small Fab         | 5091267   |
| 52 91595A034                  | Dowel Pin, M2 X 20mm                   | 2 Ea (2 ea) | 110-Small Fab         | 5093345   |
| 54 98543A114                  | E-Clip, Ø7-9mm Shaft                   | 3 Ea (3 ea) | 110-Small Fab         | 5093349   |
| QC6? RBEM622U3001101-1        | Extractor Weldment                     | 1 Ea (1 ea) | 110-Small Fab         | 5114860   |
| outsourced RBEM622U3001101-13 | Bolt Weldment                          | 1 Ea (1 ea) | 110-Small Fab         | 5114705   |
| 134A RBEM622U3001101-7        | Base Plate                             | 1 Ea (1 ea) | 110-Small Fab         | 5104531   |
| 134A RBEM622U3001101-9        | Extractor Bottom                       | 1 Ea (1 ea) | 110-Small Fab         | 5113665   |
| 40 97524A032                  | Sealing Blind Rivet                    | 4 Ea (4 ea) | 130-Small Fab         | 5089128   |
| 97F APP-1300-E                | Case                                   | 1 Ea (1 ea) | 130-Small Fab         | 5114736   |
| 140E RB41011                  | Dart Tooling Placard, Aluminum         | 1 Ea (1 ea) | 130-Small Fab         | 5021040   |
| 97F RBEM622U3001101-27        | Bottom Foam use in case APP-1300-E     | 1 Ea (1 ea) | 130-Small Fab         | 5114734   |
| 97F RBEM622U3001101-29        | Top Foam use in case APP-1300-E        | 1 Ea (1 ea) | 130-Small Fab         | 5114735   |

| Job Allocations                        |                    |          |           |           |
|----------------------------------------|--------------------|----------|-----------|-----------|
| Operation                              | Component Part     | Required | Inventory | Allocated |
| 90-Start up Operation<br>110-Small Fab | RBEM622U3001101-11 | 3        | 6         | 0         |
|                                        | 90128A263          | 2        | 100       | 0         |
|                                        | 91166A270          | 3        | 207       | 0         |
|                                        | 91595A034          | 2        | 50        | 0         |
|                                        | 98543A114          | 3        | 100       | 0         |
|                                        | RBEM622U3001101-1  | 1        | 2         | 0         |
|                                        | RBEM622U3001101-13 | 1        | 4         | 0         |
|                                        | RBEM622U3001101-7  | 1        | 8         | 0         |
|                                        | RBEM622U3001101-9  | 1        | 2         | 0         |
|                                        | 97524A032          | 4        | 987       | 0         |
| 130-Small Fab                          | APP-1300-E         | 1        | 2         | 0         |
|                                        | RB41011            | 1        | 763       | 0         |
|                                        | RBEM622U3001101-27 | 1        | 1         | 0         |
|                                        | RBEM622U3001101-29 | 1        | 1         | 0         |
| Part Specifications                    |                    |          |           |           |
| Specifications could not be found.     |                    |          |           |           |

Plex 10/11/18 11:46 AM dart.logan.david



Container No: S118987



Part: RBEM622U3001101

Job No: 181877

Serial No/Batch: S118987

Revision: 2

Inspector:

Exp Date:

Instructions:

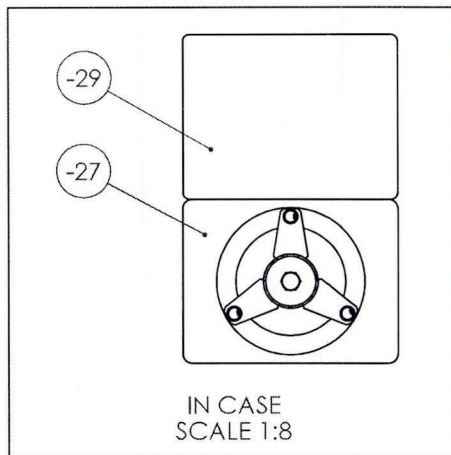
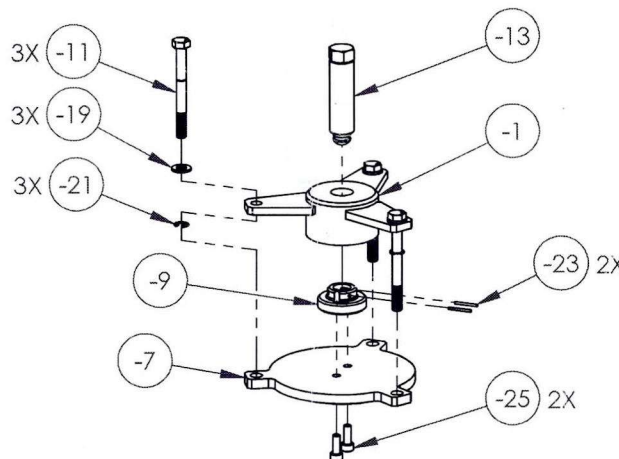
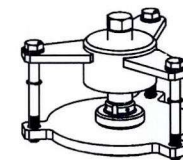
Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 10/16/18



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| REVISIONS |         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |            |         |          |
|-----------|---------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|---------|----------|
| REV       | ECR     | DESCRIPTION                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | DATE       | INITIAL | APPROVED |
| 1         |         | RELEASED FOR PRODUCTION.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 5/10/2016  | DPD     | JAG      |
| 2         | 16-0172 | -1, -7, -9, -11, 13 CH'D FINISH WAS QMSI-6.2.2, REV D IS QSMI-6.2.2, B.O. REV D. -3 ADDED ENGRAVE T/N, S/N, "MADE IN USA" NOTE. -5 CH'D MATERIAL WAS 1018/1020 CR IS 4140/4142, ADDED HEAT TREAT RC 28-32. -7 CH'D MATERIAL WAS 1018/1020 CR IS 4140/4142, ADDED HEAT TREAT RC 28-32. -9 CH'D NOTE WAS F.F. -27 IS (P.F. -23). -27 CH'D DIM WAS 4X R.41 IS 4X 1.00 X 45°. -27 & -29 CH'D MATERIAL WAS Y20 BLACK I.R. SPECIALTY IS ETHAFOAM 220, BLACK, (CASE SOLUTIONS). -29 CH'D DIM WAS 4X R.29 IS 4X .50 X 45°. | 10/14/2016 | RJC     | SM       |



| ASSY QTY | ASSY QTY | B/O | Part # | UNIT QTY | Description           | Material            | B/O INFORMATION OR SPECIFICATIONS                   | PG. |
|----------|----------|-----|--------|----------|-----------------------|---------------------|-----------------------------------------------------|-----|
|          | X        |     | -1     | 1        | EXTRACTOR WELDMENT    |                     |                                                     | 2   |
|          | 1        |     | -3     |          | CENTER                | 1018/1020 CR        |                                                     | 3   |
|          | 3        |     | -5     |          | EAR                   | 4140/4142           |                                                     | 4   |
|          |          |     | -7     | 1        | BASE PLATE            | 4140/4142           |                                                     | 5   |
|          |          |     | -9     | 1        | EXTRACTOR BOTTOM      | 1018/1020 CR        |                                                     | 6   |
|          |          |     | -11    | 3        | HEX HEAD CAP SCREW    | STEEL               | M8 X 1mm X 80mm (FASTENAL #38417) MODIFIED          | 7   |
| X        |          |     | -13    | 1        | BOLT WELDMENT         |                     |                                                     | 8   |
| 1        |          |     | -15    |          | THREADED ROD          | B7                  | M20 X 1.5mm X 100mm (MCMaster-CARR #95245A178) MOD. | 9   |
| 1        |          | B/O | -17    |          | HEX NUT               | STEEL               | M12 X 1.75mm (MCMaster-CARR #90592A028)             | 8   |
|          |          | B/O | -19    | 3        | WASHER                | STEEL               | M8 (MCMaster-CARR #91166A270)                       | 1   |
|          |          | B/O | -21    | 3        | E-CLIP                | STEEL               | Ø7-9mm SHAFT (MCMaster-CARR #98543A114)             | 1   |
|          |          | B/O | -23    | 2        | DOWEL PIN             | STEEL               | M2 X 20mm (MCMaster-CARR #91595A034)                | 1   |
|          |          | B/O | -25    | 2        | SOCKET HEAD CAP SCREW | STEEL               | M6 X 1mm X 15mm (MCMaster-CARR #90128A263)          | 1   |
|          |          | B/O | -27    | 1        | BOTTOM FOAM           | ETHAFOAM 220, BLACK | 4.97 X 7.12 X 9.28 (CASE SOLUTIONS)                 | 10  |
|          |          | B/O | -29    | 1        | LID FOAM              | ETHAFOAM 220, BLACK | 1.20 X 7.21 X 9.25 (CASE SOLUTIONS)                 | 11  |
|          |          | B/O | -31    | 1        | CASE                  | PLASTIC             | PELICAN #APP-1300-E                                 | N/S |
|          |          | B/O |        | 1        | DART PLACARD          | ALUMINUM            | RB41011                                             | N/S |
| ASSY -13 | ASSY -1  |     |        |          |                       |                     |                                                     |     |

NOTE:  
REF. AIRBUS T/N: M622U3001101.



## CONICAL EXTRACTOR

|                   |  |                                                        |  |
|-------------------|--|--------------------------------------------------------|--|
| TITLE             |  | REV                                                    |  |
| CONICAL EXTRACTOR |  | 2                                                      |  |
| DWG NO.           |  | RBEM622U3001101                                        |  |
| MAT'L             |  | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES |  |
| HEAT TREAT        |  | .xxx ± .005 FRACTIONS ± 1/8                            |  |
| FINISH            |  | .xx ± .01 ANGLES ± 5°                                  |  |
| SPEC              |  | .x ± .1 SURFACES = 125/✓                               |  |
| DRAWN BY:         |  | 1. BREAK ALL SHARP EDGES<br>.015 x 45° OR .015R        |  |
| CHECKED:          |  | 2. DIMENSIONAL LIMITS APPLY<br>AFTER PLATING           |  |
| OPPS APPR:        |  | 3. INTERPRET DIM AND TOL PER<br>ASME Y14.5M-2009       |  |
| QA APPR:          |  | USED ON MODEL                                          |  |
| APPROVED:         |  | H175                                                   |  |
| SCALE             |  | 1:6                                                    |  |
| DATE              |  | 4/15/2016                                              |  |
|                   |  | SHEET 1 OF 11                                          |  |